

Date: Friday, 11/11/2005 2:40:03 PM
 User: Linda Lacelle

Process Sheet

| | |
|---|--|
| Customer : CU-DAR001 Dart Helicopters Services | Drawing Name : 206 A/B HIGH GEAR WEB |
| Job Number : 24749 | |
| Estimate Number : 10455 | |
| P.O. Number : N/A | Part Number : D26543 |
| This Issue : 11/11/2005 S.O. No. : N/A | Drawing Number : D2654 REV E1 |
| Prsht Rev. : NC | Project Number : N/A |
| First Issue : N/A Type : LANDING GEAR | Drawing Revision : E1 |
| Previous Run : N/A | Material : N/A |
| Written By : <u>See comment below</u> | Due Date : 11/30/2005 Qty: 4 Um: Each |
| Checked & Approved By : <u>See comment below</u> | |
| Comment : Est Rev:D 99.02.04 Fixed typo, Changed procedureDM | |

Additional Product

Job Number:



| Seq. #: | Machine Or Operation: | Description : |
|---------|-----------------------|---------------|
|---------|-----------------------|---------------|

| | | |
|-----|-----------|-------------------------|
| 1.0 | D26005108 | Extrusion 'I Beam' thin |
|-----|-----------|-------------------------|



Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s)
 Pick:

| Qty | Part Number | Description | Batch |
|-----|-------------|-------------|--------|
| 1 | D2600-5 | Web | B12437 |

pmc 05-12-8

| | | |
|-----|----------------|-------------------------|
| 2.0 | LANDING GEAR 1 | LANDING GEAR RESOURCE 1 |
|-----|----------------|-------------------------|

**Comment:** LANDING GEAR RESOURCE 1

1-Cut D2600-5 to length as per Dwg D2654 *pmc 05-12-8*

2-Drill pilot holes in web using drill jig DT 8018-3 as per Dwg D2654 *pmc 05-12-8*

3-Using the uni-bit, open holes to finish size as per Dwg D2654 *pmc 05-12-8*

4-Deburr holes and ends *pmc 05-12-8*

| | | |
|-----|-----|------------------------------|
| 3.0 | QC5 | INSPECT WORK TO CURRENT STEP |
|-----|-----|------------------------------|



Comment: INSPECT WORK TO CURRENT STEP *BF 05-12-08*

| | | |
|-----|-----------------|----------------------------|
| 4.0 | HAND FINISHING1 | HAND FINISHING RESOURCE #1 |
|-----|-----------------|----------------------------|

**Comment:** HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1 *A.M 05-12-08*

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Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 206 A/B HIGH GEAR WEB

Job Number: 24749

Part Number: D26543

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

DP 05-12-9

6.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: LG 9.11.05-12-09

7.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21






5.11.05 05/12/12 (Y)

SD 05/12/12

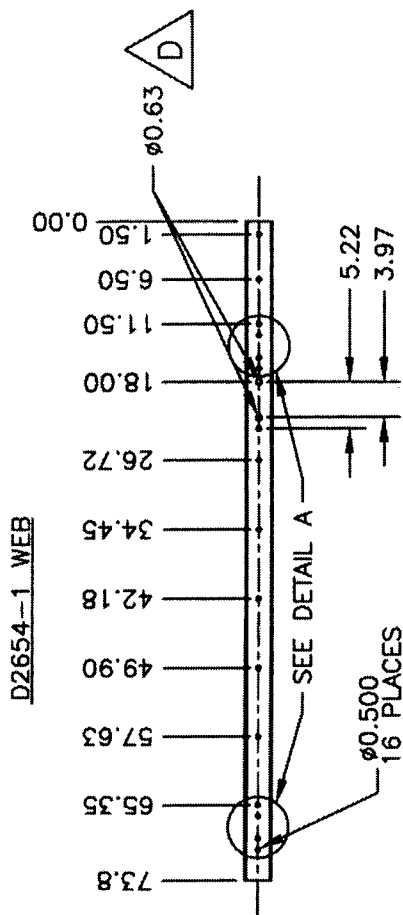
Job Completion



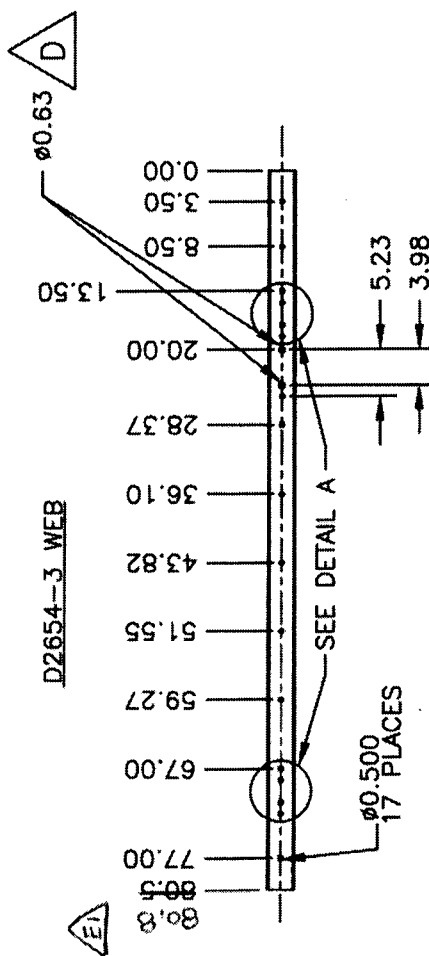


| | | | | | |
|--|--|---|------------------------------------|--|------------------------|
| DESIGN  | | DRAWN BY  | | DART AEROSPACE USA, INC. PORT HADLOCK, WA | |
| CHECKED  | | APPROVED  | | DRAWING NO. D2654 | REV. E SHEET 1 OF 2 |
| DATE 04.05.26 | | | | TITLE WEB | SCALE 1:20 |
| A | 97.03.25 | | NEW ISSUE | | |
| B | 97.06.26 | | ALTER HOLE PATRN., 0.500 WAS 0.438 | | |
| C | 97.10.29 | | CHANGED HOLE PATTERN | | |
| D | 98.01.15 | | GHW HOLES CHANGED TO Ø0.63 | | |
| E | 04.05.26 | | CHANGE LENGTHS, REFORMAT | | |
| E1 |  04.08.04 | | PER TOOLING; Ø0.8 WAS Ø0.5 | | |

RELEASED
04.06.22



DETAIL A
SCALE 1:10



MAKE FROM D2600-5-108 EXTRUSION
FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

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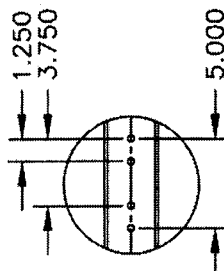
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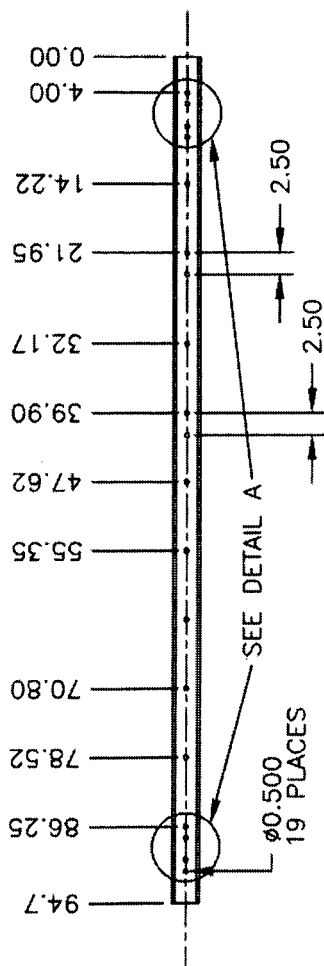
| | | | |
|-------------------------------|--------------------------------|--|------------------------|
| DESIGN <i>CP</i> | DRAWN BY <i>CP</i> | DART AEROSPACE USA, INC. PORT HADLOCK, WA | |
| CHECKED <i>[Signature]</i> | APPROVED <i>[Signature]</i> | DRAWING NO. D2654 | REV. E SHEET 2 OF 2 |
| DATE 04.05.26 | | TITLE WEB | SCALE 1:20 |

RELEASED
04.06.22

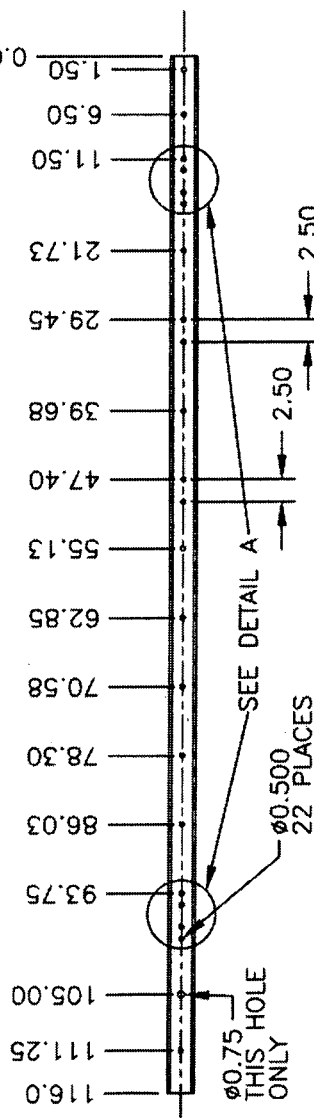
DETAIL A
SCALE 1:10



D2654-5 WEB



D2654-7 WEB



MAKE FROM D2600-7-125 EXTRUSION
FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

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Job Costing Report

Dart Aerospace Ltd.
Hawkesbury

Nov 10, 2005
07:04 am

| | | | |
|-------------------|--------------------|------------------------------|----------------|
| Work Order No | : 0024749 | Department Code: | |
| Project Name | : D2654-3 | Burden Flags | : NNNNNNN |
| Project For | : WK547 | WO Status | : Open |
| Work Order Type | : Main | Invoice State | : Not Invoiced |
| Main WO Number | : | Invoice Date | : |
| House Part Number | : D2654-3 | Invoice Number | : |
| Description | : 206 I-Beam (Web) | Invoice Amount | : 0.00 |
| Manufactured | : Yes | | |
| Amount Req'd | : 4 | Order Entry No | : |
| Amount Done | : 0 | OE Value | : 0.00 |
| Start Date | : 11-09-05 | | |
| Est Finish Date | : 11-24-05 | Est Margin | : 0.000% |
| Act Finish Date | : | Actual Margin | : 0.000% |
| Drawings Req'd | : No | | |
| Ok for Approval | : | | |
| Approval Rec'd | : | \$0 Posted to Finished Goods | |

| | Estimated | Actual | Var. % | Posted | To Post |
|-------------------|-----------|--------|--------|--------|---------|
| Material Cost | : 0.00 | 0.00 | 0.00 | 0.00 | 0.00 |
| Engineering Hours | : 0.00 | 0.00 | 0.00 | | |
| Engineering Cost | : 0.00 | 0.00 | 0.00 | 0.00 | 0.00 |
| Production Hours | : 0.00 | 0.00 | 0.00 | | |
| Production Cost | : 0.00 | 0.00 | 0.00 | 0.00 | 0.00 |
| Packaging Hours | : 0.00 | 0.00 | 0.00 | | |
| Packaging Cost | : 0.00 | 0.00 | 0.00 | 0.00 | 0.00 |
| OverHead Hours | : 0.00 | 0.00 | 0.00 | | |
| OverHead Cost | : 0.00 | 0.00 | 0.00 | 0.00 | 0.00 |
| CNC Hours | : 0.00 | 0.00 | 0.00 | | |
| CNC | : 0.00 | 0.00 | 0.00 | 0.00 | 0.00 |
| Misc. Hours | : 0.00 | 0.00 | 0.00 | | |
| Misc. | : 0.00 | 0.00 | 0.00 | 0.00 | 0.00 |
| Burden | : 0.00 | 0.00 | 0.00 | | |
| Total Cost | : 0.00 | 0.00 | 0.00 | | |
| Margin | : 0.000 | 0.000 | | | |
| Selling Cost | : 0.00 | 0.00 | | | |

| | Estimated | Actual |
|------------------------|-----------|--------|
| Labour Hrs/Amount Done | : 0.00 | 0.00 |
| Profits/(Loss) | : 0.00 | 0.00 |